Work Order I		28		*11(Page 1			
Item ID: D35 Revision ID:			•	Accept	*N900	<u>040</u>	100) * :	Setup Sta	17	S1* S2*
Start Date: 12/2 Required Date: 12/3 Reference:		Start Qty: 20.00 Req'd Qty: 20.00	*20 *20	and the second s	Cust Item l Customer:	ID:					
Approvals: Pro	ocess Plan:	MIS	Date: <u>/3-/2-</u>	23Tooling:	D:	ate:		1	Run Sta	1/1	R1*
QC	:		Date:	SPC (Y/N):	D:	ate:			Sto	, *N	R2*
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3589	Ć										
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110	Q	C2- Inspect parts off i	machine FAI/FAIB	0.00							
110 oc		Memo		0.00				20	φ_		JH203122

Memo

Quality Control

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE						DART			
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Part N	lo.					Scrap		Machining Small Fab			Prod. Eng. Coor.			Quality	
NCR N	۱٥٠ ِ					Use-as-is Thermoforming Finishing Suspected Unapproved Large Fab Composite			Rec/Store/Packaging Supplie			Other			
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Cause		Date	Step	Qty		or non-conformance Chief Eng Description			Date	Verification		QC Inspector			
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	Ŭ	Bending				Bend	Г	Folio/F	rogram			Outside Dim	ensions [Pressure/Forced
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	Г	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ci [Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruc	tions Incomplete/	'Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misali	ned/off center			Positioned V			
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		Inspectio	n Strip in	Tube		Drawing		Misrea	d			_			
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
	Turning Sequence Wave/Twist in Tube			Fit/Function		Out of	Sequence								

W	ork	Order	ID	110528
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110528

Page 2

December-23-13 12:44:51 PM D3589-3 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Arm Guide *20* **Start Date:** 12/23/13 **Start Oty: 20.00 Cust Item ID:** Required Date: 12/30/13 Req'd Qty: 20.00 *20* **Customer:** Reference: Run Start Process Plan: Date: **Tooling: Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Tool ID Tool # Plan Sequence ID/ **Operation** Set Up/ Reject Reject Accept Insp. **Work Center ID** Qty Qty Stamp **Description** Code Number **Run Hours** 120 0.00 DAS 40 QC8- Inspect parts - second check *120* QC 0.00 Memo 13/12/28 Quality Control Identify as per dwg & Stock Location: WACO? 0.00 130 *120* 13-12-30 0.00 Packaging Memo Packaging Pm 13/12/31

MC
(3-12-3) 140 QC21- Final Inspection - Work Order Release 0.00 *140* QC 0.00Memo Quality Control

DQA:			Date:			_									
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QA Closed:			Date:								Wo	ork Order up	date only		-
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		Crimp/Kin	k/Rinnla	/Mave		Burrs		Hardware		-	Part Lost/Mi	<u> </u>	_	Weld	
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		Turning S				Finish		4	Calibration						
		Wave/Tw	-			Fit/Function		Out of	Sequence						

Picklist Print

December-23-13 12:44:54 PM

Work Order ID: 110528

110528

Parent Item:

D3589-3

D3589-3

Parent Item Name: Arm Guide

Start Date: 12/23/13

Required Date: 12/30/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 08-05-29 new issue DD verified by:EC

iPP Rev:B

09-02-20 rev.b asper dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500		Purchased	No		100	f	60.0000	0.05	2			
*N/20/P 5	^^				**							

W3U4H 500

304 SS roundbar .500

Location	Loc Oty	Loc Code			
MAT029	60				
115334	2				
117890	10		2	びた	2013-12-24
m126151	48				•

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		····-
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Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.		Quality
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		Cuffs		,		Contamination		1 '	tions Incomplete/Unclear		Part Moved	-	_	Vrong Stock Pulled
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		Heat Trea	nt			Cut Too Short		Mislab		一	Power Loss/		٦٥	ther
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		Wave/Tw				Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	110528
Description: Arm Guide	Part Number:	D3589-3
Inspection Dwg: D3589 Rev: BC Rev. 212/23		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

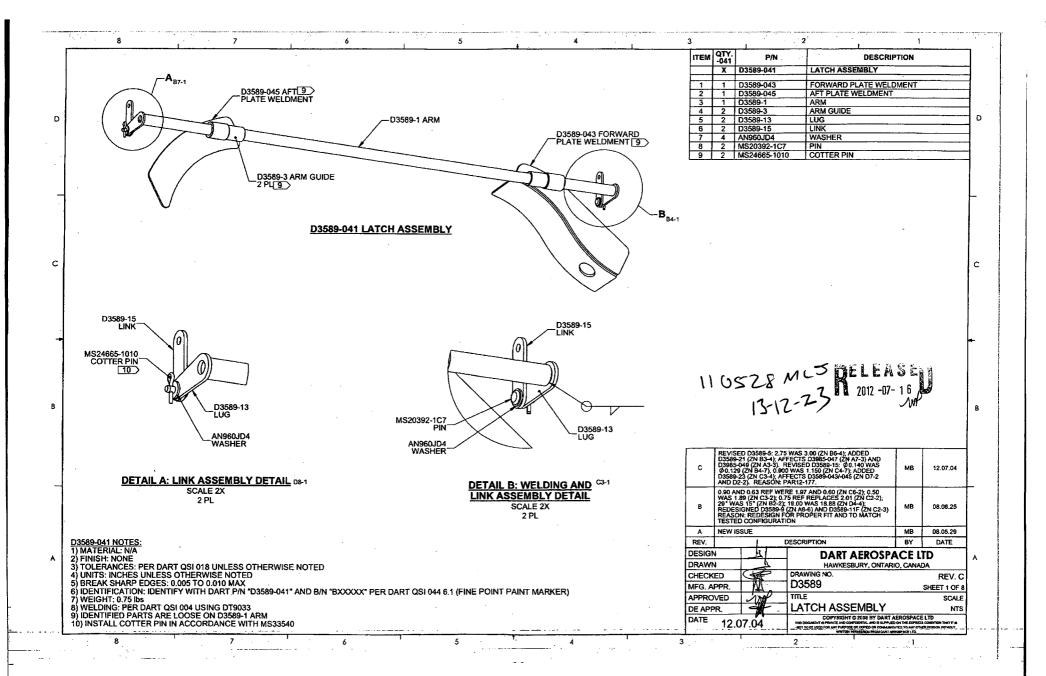
X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+/-0.010	0.500	/		Calipa	JFC-01
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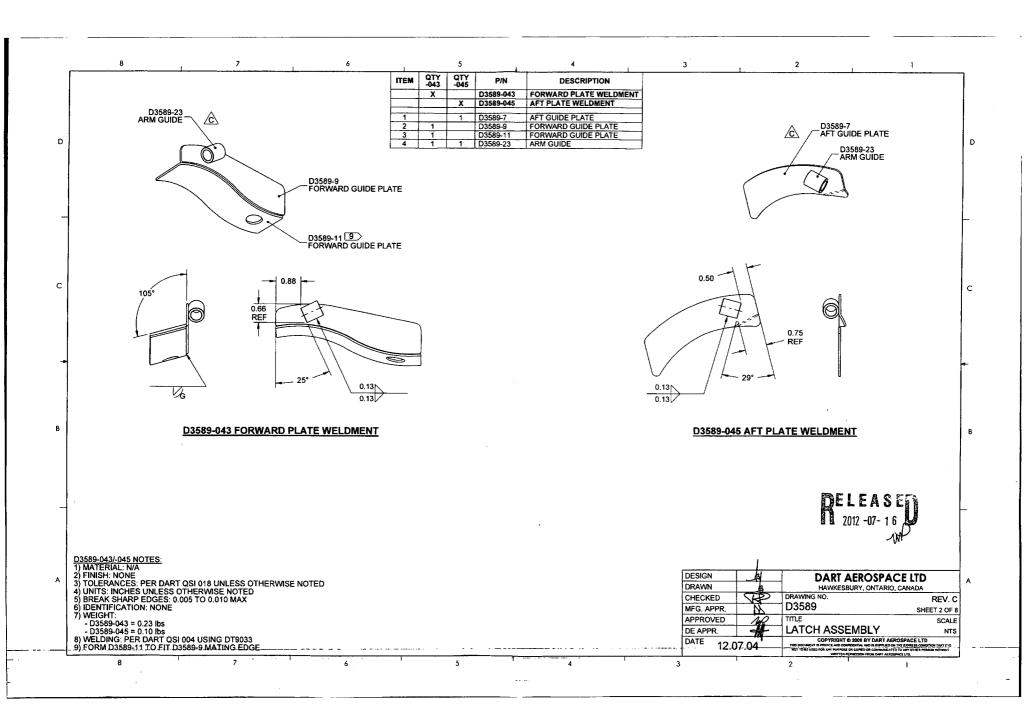
		OAS		
Measured by: JfC	Audited by:	40	Prototype Approval:	N/A
Date: 2013-12-24	Date:	13/12/28	Date:	N/A

Rev	Date	Change	Revised		Approved	
Α	09.05.07	New Issue	KJ/EC	94		
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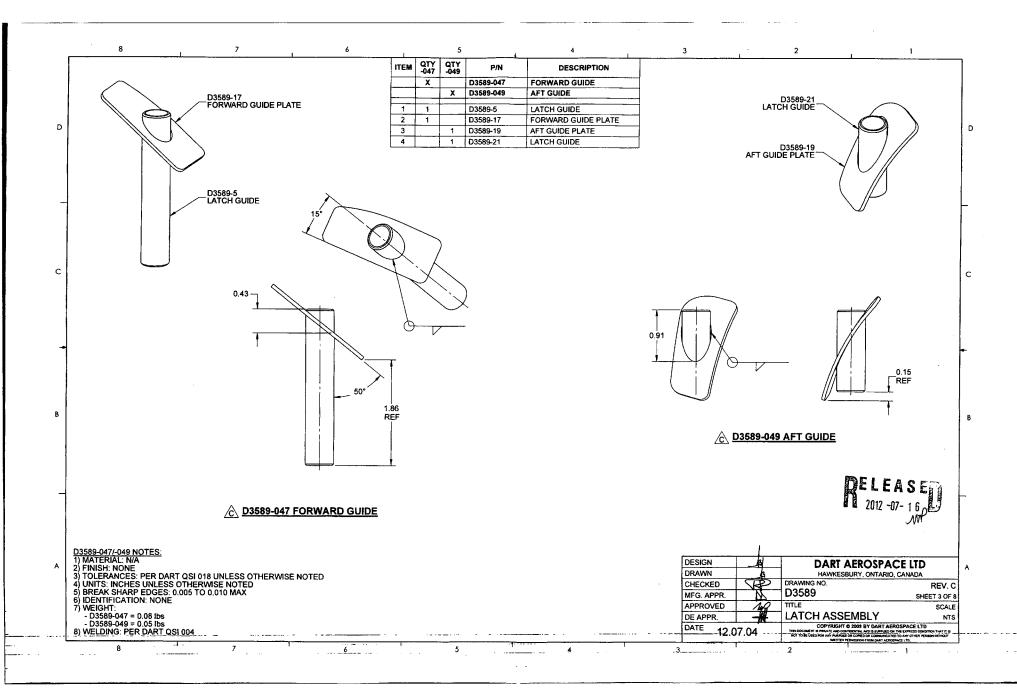
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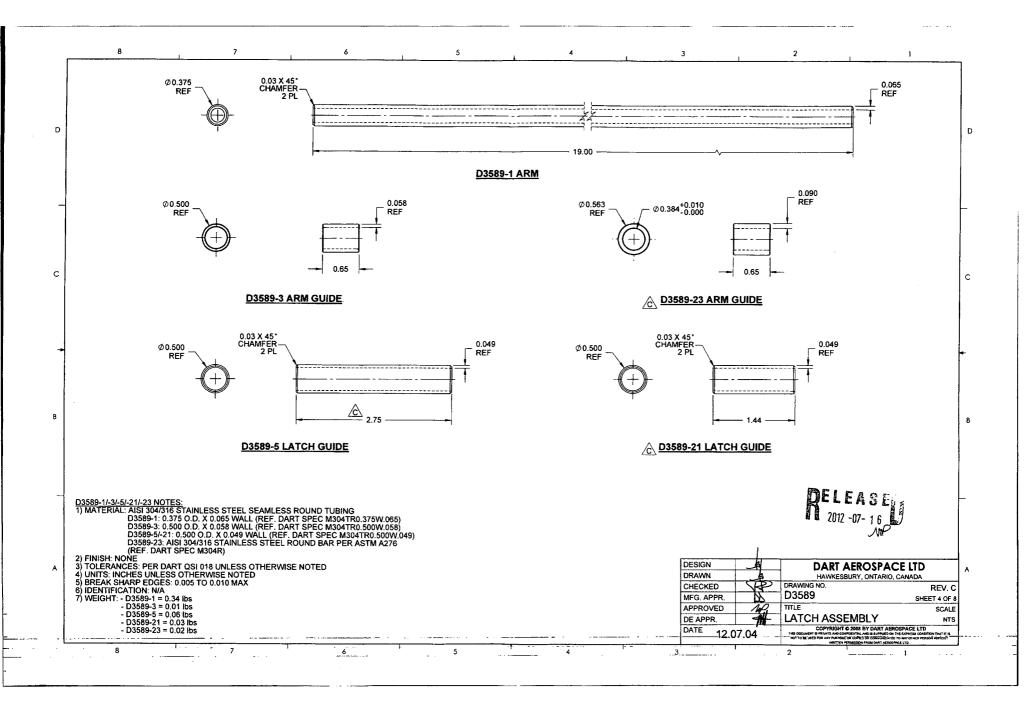
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	Wave/Twist in Tube					Fit/Function		Out of	Sequence					



DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				_	AEROSPACE			
QA Closed:			Date:		- ,					w	ork Order up	date only					
Work Orde	er:					DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS					
	-			,	_	Rework			Skid-tube Crosstu	ьеГ	1	Water Jet	\Box	Engineering			
Part N	lo.				i	Scrap			Machining Small F		Pro	d. Eng. Coor.	٦	Quality			
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	Cracks				L	Broken/Damage/Defect	L	Hardwa	are	L	Part Incorred	ાં _		Temperature/Cure			
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	- l-		Weld			
	Cuffs					Contamination	L	Instruct	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled			
	Crushing					Countersink		Misalig	gned/off center		Positioned V						
	Heat Treat					Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other			
	Inspection Strip in Tube					Drawing		Misrea	d								
	Marks/Chatter					Drill Holes		Off-set									
	Turning Sequence					Finish	Out of Calibration										
	Wave/Twist in Tube					Fit/Function		Out of	Sequence								

R0.25 2 PL REF 2.16 R4.90 R0.16 2 PL 2.24 2.74 MAKE FROM D3589-7F 2.64 **D3589-7F AFT GUIDE PLATE FLAT PATTERN**

0.45 **D3589-7 AFT GUIDE PLATE**

2

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. C D3589 MFG. APPR. SHEET 5 OF 8 APPROVED TITLE SCALE DE APPR. LATCH ASSEMBLY NTS DATE 12.07.04

8

D3589-7/-TF NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH

16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

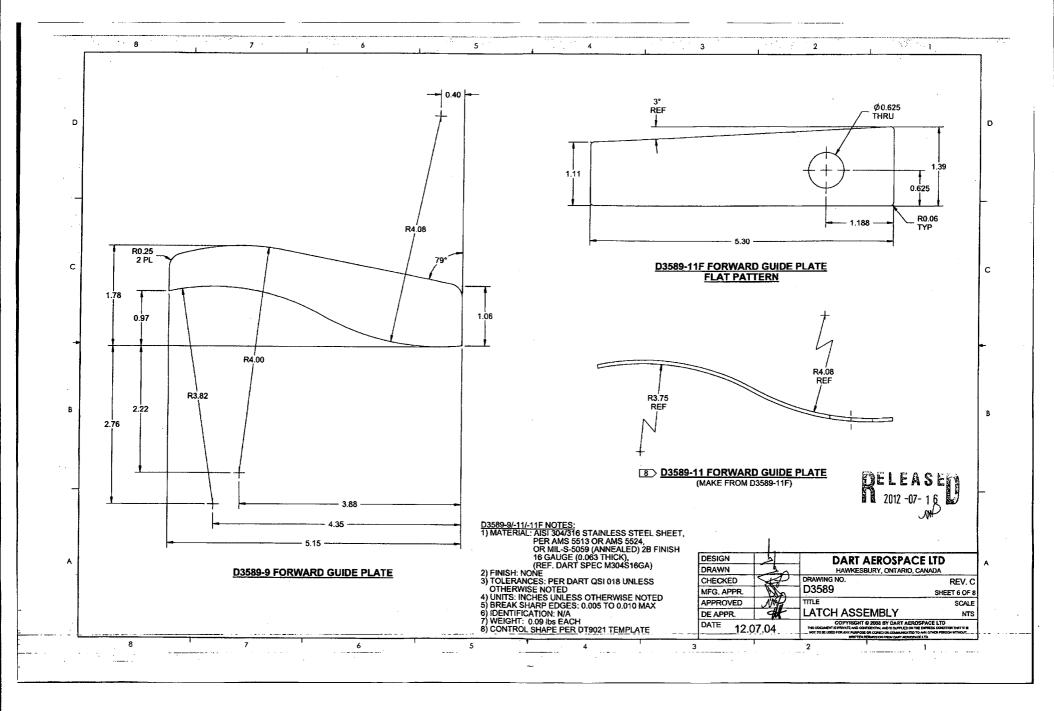
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.09 lbs

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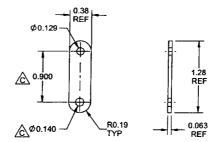
DQA:	Date:													
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	r:					DISPOSITION			AGAINST	ΓDE	PARTMENT	/PROCESS		
************	•				_	Rework		·	Skid-tube Crosstube]	Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining Small Fat	_	Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Therr	noforming Finishing	3	Rec/Sto	re/Packaging		Other
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
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	Centre Not Concentric				-	Broken/Damage/Defect	-	Hardwa	are	\vdash	Part Incorre		_	Temperature/Cure
	Cracks Crimp/Kink/Ripple/Wave					Burrs	-	1	ion Incomplete/Unqualified		Part Lost/Mi	<u>-</u>	_	Weld
	Cuffs Cuffs					Contamination		1	tions Incomplete/Unclear		Part Moved	-	_	Wrong Stock Pulled
	Crushing					Countersink		4	gned/off center	\vdash	Positioned V	L Vrong		og otoom anda
	\vdash	Heat Trea	ıt			Cut Too Short	H	Mislab	-	\vdash	Power Loss/		\neg	Other
		Inspection		Tube		Drawing	H	Misrea			J	· [L	·
	<u> </u>	Marks/Ch	•			Drill Holes		Off-set						
├ ─┤						Finish	Out of Calibration							
Wave/Twist in Tube						Fit/Function		Out of Sequence						



DQA:			Date:				RK ORDER NON-CONFORMANCE / UPDATE							
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			–	AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
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	-					Use-as-is		ì	noforming Finishi	_	4	e/Packaging	Other	
NCR N	lo.					Suspected Unapproved			Large Fab Composi]	Supplier		
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
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		Bending				Bend		1	Program	\perp	Outside Dim	_	Pressure/Forced	
	Centre Not Concentric					BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks					Broken/Damage/Defect		Hardwa	are	\perp	Part Incorre	cí _	Temperature/Cure	
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	issing	Weld	
	Cuffs					Contamination		4	tions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		4	gned/off center	L	Positioned V	_		
		Heat Trea	at			Cut Too Short		Mislab	eled	L	Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea				·		
		Marks/Ch	natter			Drill Holes	L	Off-set						
	Turning Sequence					Finish	Out of Calibration							
	Wave/Twist in Tube					Fit/Function		Out of	Sequence					

Ø0.129 THRU R0.18 -0.935 REF Ø0.250 0.063 R0.25 THRU

D3589-13 LUG



D3589-15 LINK

D

С

D3589-13/-15 NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)

DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C D3589 MFG. APPR. SHEET 7 OF 8 APPROVED TITLE SCALE LATCH ASSEMBLY DE APPR. DATE

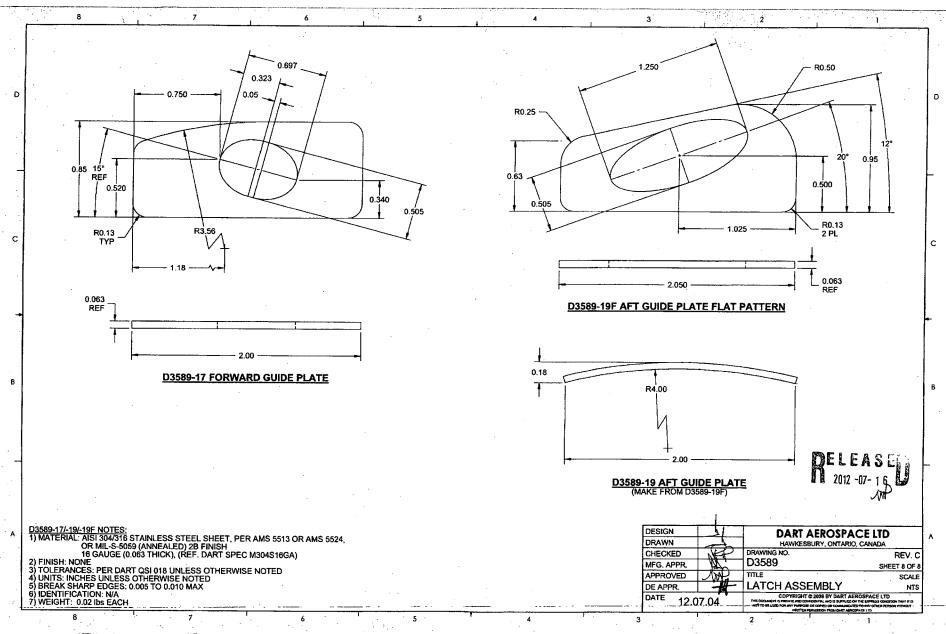
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16 GAUGE (0.063 THICK), (REP. DAKT SPEC MIGO4S TOC 2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.01 lbs EACH

8

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			-	AEROSPACE			
QA Closed:			Date:						*··-	W	ork Order up	date only	L			
Work Orde	ır.					DISPOSITION			AGA	INST DE	PARTMENT	PROCESS				
WOIK OIGE						Rework			Skid-tube Cross	tube	1	Water Jet	Engineering			
Part N	lo.					Scrap			Machining Small	_	Pro	d. Eng. Coor.	Quality			
	••••					Use-as-is			Ŭ	hing	4	e/Packaging	Other			
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Root					Desci	ription of work order update		nitial	Action		Sign &					
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	Centre Not Concentric Cracks					Broken/Damage/Defect		Hardw	are		Part Incorred	<u> </u>	Temperature/Cure			
	Cracks Crimp/Kink/Ripple/Wave					Burrs	\vdash	4	tion Incomplete/Unqualified	,	Part Lost/Mi	-	Weld			
	Cuffs					Contamination	T	· '	tions Incomplete/Unclear		Part Moved	Ť	Wrong Stock Pulled			
	Crushing					Countersink	\vdash	4	gned/off center		Positioned V	Ŭ. Vrong				
1						Cut Too Short		Mislab			Power Loss/		Other			
	Inspection Strip in Tube Draw					Drawing		Misrea	d	!	_					
		Marks/Ch	-			Drill Holes		Off-set								
Turning Sequence						Finish	Out of Calibration									
	Wave/Twist in Tube					Fit/Function		Out of Sequence								



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						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
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	•				_	Use-as-is	۱ ا	i	noforming Finishir	ng 🗀	4	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composit	te]	Supplier	
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Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Transport	L_												
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		Bending			<u> </u>	Bend	_	4	Program	<u> </u>	Outside Dim	-	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under		Set-up
	Cracks					Broken/Damage/Defect		Hardwa		 	Part Incorre	 	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs	<u>_</u>	1 .	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	issing	Weld
		Cuffs			_	Contamination		-1	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		┥	gned/off center		Positioned V		_
	_	Heat Trea			<u> </u>	Cut Too Short	L	Mislab		L	Power Loss/	'Surge	Other
	<u></u>	Inspectio		Tube		Drawing	L	Misrea					
	L	Marks/Cl				Drill Holes	\perp	Off-set					
		Turning S			L	Finish		Out of	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of	Sequence				